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(19) (CA) **CANADIAN PATENT** (12)

(54) Tubular Casing Having an Adhesive Tape in the Direction
of its Longitudinal Axis

(72) Kastl, Erna , Germany (Federal Republic of)
Mathieu, Marion , Germany (Federal Republic of)
Goerres, Anton , Germany (Federal Republic of)

(73) Hoechst Aktiengesellschaft , Germany (Federal Republic
of)

(30) (DE) Germany (Federal Republic of) G 88 04 813.6
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Abstract of the Disclosure

5. A tubular food casing comprising a film which
has been bent to form a tubing, the longitudinal
edges of which are joined to one another by means of
an adhesive tape, which forms a glued seam. The
adhesive tape comprises a plurality of incisions,
ending in the area of the glued seam, which extend
transversely to its longitudinal direction. In the
area of the incision ends, the adhesive tape is
10 firmly bonded to the film. The bond strength
between the adhesive tape and the film is greater
than the tear resistance of the film.

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TUBULAR CASING HAVING AN ADHESIVE TAPE
IN THE DIRECTION OF ITS LONGITUDINAL AXIS

Background of the Invention

5 The present invention relates to a tubular
food casing, in particular an artificial sausage
casing, formed from a film bent into tubular form
and sealed with an adhesive tape.

10 Tubular casings of this kind are disclosed,
for example, in EP-B 0 037 543 and 0 054 162; the
manufacture of these casings is described, in
particular, in EP-A 0 080 120 and in DE-A 32 44 372;
and a device for the manufacture thereof is
described in EP-A 0 224 808.

15 These tubular casings have the disadvantage
that it is difficult to peel them from a filling, in
particular from sausage meat, in a spiral manner,
i.e. in the direction of the tubing circumference.
Tearing of the tubular film usually stops at the
20 adhesive tape which extends along the longitudinal
axis of the tubing, across the track of tearing,



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such that further tearing of the film is rendered practically impossible. The adhesive tape must be cut with a tool, before tearing of the film can be resumed.

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Summary of the Invention

It is therefore an object of the present invention to improve tubular casings having an adhesive tape, in such a way that the casings can be removed from a filling without difficulty.

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In accomplishing the foregoing objective, there has been provided, in accordance with one aspect of the present invention, a tubular food casing comprising a film bent to form a tubing and an adhesive tape extending in the longitudinal direction of the tubing, the adhesive tape joining those edges of the film which extend in the longitudinal direction of the tubing such that a glued seam is formed between the adhesive tape and the edges, wherein the adhesive tape comprises a plurality of incisions extending transversely from at least one longitudinal edge of the tape, wherein each of the incisions terminates at a point located within the glued seam, and wherein the bond strength between the adhesive tape and the film is greater than the tear resistance of the film.

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In accordance with another aspect of the present invention there is provided a sausage

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product comprising a sausage meat emulsion and a casing as described above.

5 Other objects, features and advantages of the present invention will become apparent to those skilled in the art from the following detailed description. It should be understood, however, that the detailed description and specific examples, while indicating preferred embodiments of the present invention, are given by way of illustration and not limitation. Many changes and modifications within the scope of the present invention may be made without departing from the spirit thereof, and the invention includes all such modifications.

15 Brief Description of the Drawings

The invention is explained in detail with reference to Figures 1 and 2.

Figure 1 shows a side view of a preferred embodiment, a sausage casing, in the filled state.

20 Figure 2 shows an enlarged cross-sectional view of the seam area of the sausage casing of Figure 1.

Detailed Description of the Preferred Embodiments

25 The sausage casing comprises a film 4 (Figure 2) carrying an external coating layer 5 and being

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bent to form a tubing, and the support film 6 of the adhesive tape which overlaps the edges 1, 2 of the film 4. The edges 1, 2 have here been drawn together to form a butt joint. The support film 6
5 shows a plurality of incisions 7 (Figure 2) which extend approximately perpendicularly to the longitudinal direction of the adhesive tape and in parallel with one another and are present at both edges of the support film 6. In Figure 2, the width
10 of adhesive layer 3 which corresponds to the width of the glued seam and the length of the incisions 7 are chosen in such a way that the support film 6 adheres firmly to the surface layer 5 of the film 4, at the ends 9 of the incisions 7. The sausage
15 casing is closed at its ends by means of metal clips, 8a, 8b (Figure 1).

In another preferred embodiment, reference numeral 3 indicates a heat sealing layer, and the coating layer 5 then comprises a heat-sealable
20 material.

The tubular casing serves for the packaging of pasty foodstuffs and is, in particular, an artificial sausage casing made of a non-edible material which must be removed prior to consumption.
25 The casing comprises a film which has been bent into a tubing and has the shape of a circular cylinder in the filled state. In the manufacture of the tubular casing, an initially sheet-shaped or web-shaped film blank or an endless film web is bent about its
30 longitudinal axis. The edge zones which extend in

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the direction of the longitudinal axis of the tubing and adjoin each other as a result of this bonding operation are joined to one another in the region of the butt seam by means of an adhesive tape which overlaps the two edge zones and follows the course of the butt seam. The adhesive tape is present on the outside or inside of the tubular casing and comprises a support film and, if required, a sealing or adhesive layer.

It is essential that the adhesive tape exhibit a plurality of incisions extending transversely, in particular perpendicularly, with respect to the longitudinal direction of the adhesive tape. It is particularly advantageous to use adhesive tapes having support films of feather-like configuration. The incisions permit uninterrupted tearing of the film of the tubular casing in the area of the adhesive tape since, within a cut, the adhesive tape breaks and tearing goes on.

In order for the casing to be perfectly removable, it is also necessary that the adhesive tape, at least in the area of the incision ends, be firmly bonded to the film of the tubular casing, i.e. the glued seam must be at least so wide that the adhesive tape adheres firmly to the film over a portion of the respective incision length, viz. at the ends of the incisions. This is particularly important in those cases, in which bonding of the adhesive tape to the film does not cover the entire width, i.e. the entire surface, of the adhesive

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tape. The bond strength between the adhesive tape and the film must moreover be greater than the tear resistance of the film since, otherwise, the adhesive tape would become detached from the film before the latter tears, in the process of peeling off the casing.

The angle included between the appropriately rectilinear incisions and the longitudinal axis of the adhesive tape should be at least 30° ; it is, however, expedient to have angles exceeding 60° .

The incisions are, in general, present at both edges of the adhesive tape, which means that the direction of tearing can be chosen at discretion, when peeling the casing from the filling. The mutual distance between the incisions should be as small as possible, such that the adhesive tape can be broken and torn virtually at any point. For this purpose, the mutual distance should not exceed about 1 cm, in particular 0.5 cm. For reasons of fabrication, the minimum spacing is about 0.5 mm. It is not necessary for the incisions to be particularly long, since even very short lengths permit tearing of the adhesive tape. In a 6 to 15 mm, in particular, 8 to 12 mm wide adhesive tape, the length of incision need not be greater than 2 mm, in particular 1 mm. Lengths of 0.5 mm or even 0.3 mm are already sufficient. The incisions can also have the shape of recesses, notches, openings and the like, which are wedge-shaped or tapered to a point.

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5 The film material of which the tubular casing
is formed has the thickness conventionally used for
flexible packagings, in particular sausage casings,
and comprises single-layer or multi-layer plastic or
cellulose films as customarily employed for these
purposes. If required, the cellulose films are
provided with a fiber reinforcement. If the
adhesive tape is attached by means of heat sealing,
the film is made of a sealable material or has at
10 least a sealable surface layer, in particular, in
the area of the seam. Suitable films exhibit, for
example, the following layer arrangements:
polyamide/PVDC (polyvinylidene chloride),
polyamide/PE, PVDC/polyamide/PE, PVDC/polyvinyl
15 alcohol/PVDC, polyester/PVDC, polyvinyl alcohol/PE,
cellulose/PVDC. The PVDC layer serves as a gas
barrier and as a sealing layer.

The support film of the adhesive tape
expediently comprises the same material as the film
20 of the tubular casing. This means that the support
film is made of a sealable material or has a sealing
or adhesive layer on that surface which enters into
contact with the film of the tubular casing. The
layer applied to one surface of the support film of
25 the adhesive tape is, for example, formed of a
pressure-sensitive adhesive, but preferably
comprises a heat sealing layer which produces the
required firm bond with the film of the tubular
casing.

What Is Claimed Is:

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1. A tubular food casing comprising a film bent to form a tubing and an adhesive tape extending in the longitudinal direction of said tubing, said adhesive tape joining the edges of said film which extend in the longitudinal direction of said tubing such that a glued seam is formed between said adhesive tape and said edges, wherein said adhesive tape comprises a plurality of incisions extending transversely from at least one longitudinal edge of said tape, wherein each of said incisions terminates at a point located within said glued seam, and wherein the bond strength between said adhesive tape and said film is greater than the tear resistance of said film.

2. The casing as claimed in claim 1, wherein the edges of said film which extend in the longitudinal direction of said tubing abut each other.

3. The casing as claimed in claim 1, wherein the edges of said film which extend in the longitudinal direction of said tubing overlap.

4. The casing as claimed in claim 1, wherein said incisions extend perpendicularly to said at least one longitudinal edge of said adhesive tape.

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5. The casing as claimed in claim 1, wherein said incisions extend from both longitudinal edges of said adhesive tape.

6. The casing as claimed in claim 1, wherein said incisions have mutual distances of about 0.5 to 10 mm.

7. The casing as claimed in claim 6, wherein said incisions have mutual distances of 0.5 to 5 mm.

8. The casing as claimed in claim 1, wherein the length of said incisions is about 0.3 to 2 mm.

9. The casing as claimed in claim 8, wherein the length of said incisions is 0.5 to 1 mm.

10. The casing as claimed in claim 1, wherein the width of said adhesive tape is about 6 to 15 mm.

11. The casing as claimed in claim 10, wherein the width of said adhesive tape is 8 to 12 mm.

12. The casing as claimed in claim 1, wherein said adhesive tape comprises a support film and an adhesive layer.

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13. The casing as claimed in claim 13, wherein said adhesive layer comprises a pressure-sensitive adhesive.

14. The casing as claimed in claim 1, wherein at least the external surface of said film and that surface of said adhesive tape which enters into contact with said film comprise a heat-sealable material, and wherein said film and said adhesive tape are bonded to one another by heat sealing.

15. The casing as claimed in claim 1, wherein said film comprises at least one layer of a plastic material.

16. The casing as claimed in claim 15, wherein said plastic material is a polyamide, a polyolefin, polyvinylidene chloride, polyvinyl alcohol or a polyester.

17. The casing as claimed in claim 1, wherein said film comprises cellulose.

18. The casing as claimed in claim 17, wherein said film further comprises a plastic coating.

19. The casing as claimed in claim 18, wherein said plastic coating is heat-sealable.

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20. A sausage product comprising a sausage meat emulsion and a casing as claimed in claim 1.

Fetherstonhaugh & Co.,
Ottawa, Canada
Patent Agents

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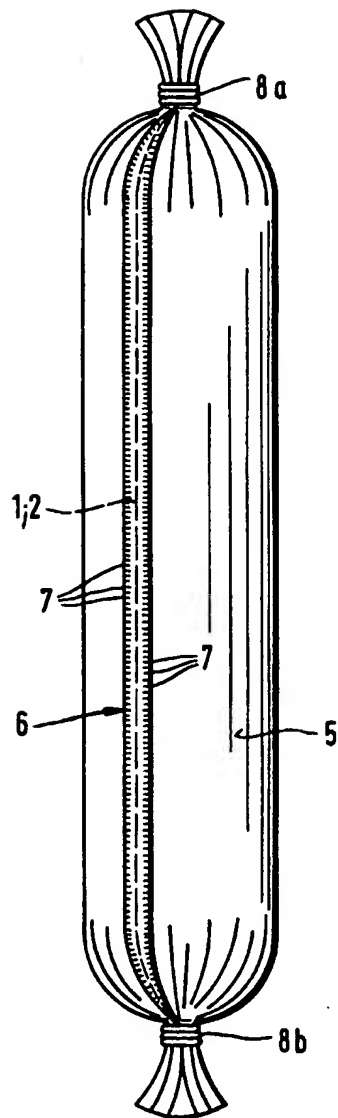


Fig. 1

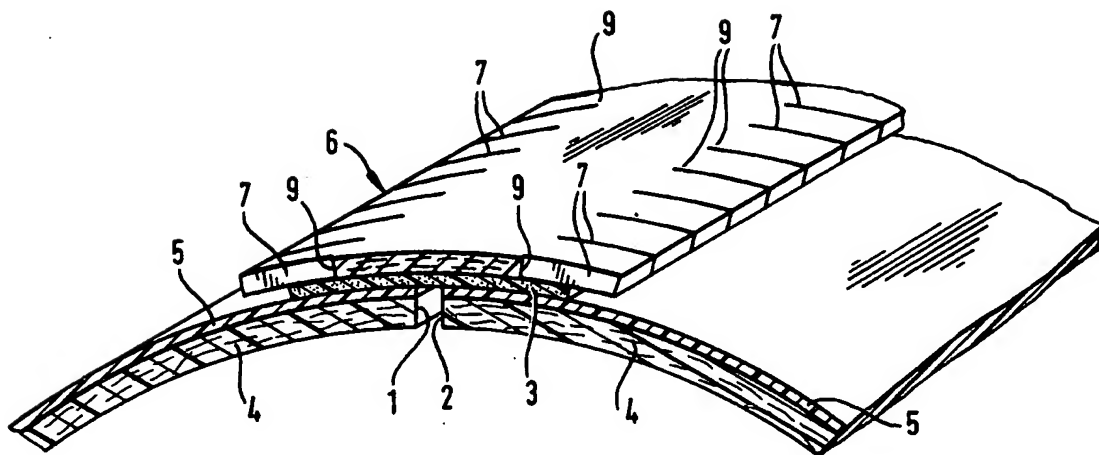


Fig. 2

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